

CLAIMS

1. Method for continuous direct casting of a metal strip according to which said strip is cast by solidification of liquid metal in an ingot mould with cooled, moving walls,  
5 said strip is then given in-line hot rolling, characterized in that a product is applied to the surface of the strip as it exits the ingot mould, which leaves a lubricant layer on said surface subsisting during the time the strip is hot rolled and causing release of gases contributing towards the protection of said surface from oxidation.
2. Method as in claim 1, characterized in that said lubricant layer is a  
10 carbonaceous material.
3. Method as in claim 2, characterized in that said product leaving a lubricant layer to subsist is graphite.
4. Method as in claim 2, characterized in that said product leaving a lubricant layer to subsist is a grease containing calcium carbonate.
- 15 5. Method as in claim 2, characterized in that said product leaving a lubricant layer to subsist is acetylene.
6. Method as in any of claims 1 to 5, characterized in that hot rolling is conducted with a reduction rate of at least 50%.
7. Method as in any of claims 1 to 6, characterized in that said liquid metal is a  
20 ferrous alloy.
8. Plant for the continuous direct casting of a thin metal strip, of the type comprising an ingot mould with cooled, moving walls in which solidification of said strip occurs, and an in-line hot rolling unit for said solidified strip, characterized in that it comprises means for applying a product to the surface of said strip as it exits the ingot mould  
25 which leaves a lubricant layer subsisting on said surface as it enters the hot rolling unit.
9. Plant as in claim 8, characterized in that said moving walls are the side walls of two rolls rotating in opposite directions.
10. Plant as in claim 8, characterized in that said moving walls are two moving belts.
- 30 11. Plant as in any of claims 8 to 10, characterized in that it comprises an inertization chamber for said strip between its exit from the ingot mould and its entry into the hot rolling unit.